



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6798925
Job Sheet 196890



Part No: RB6798925

Job Qty: 2 pcs

Part Name: Gas Producer 2Nd Stage Wheel Locknut Crimper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/24/19

Job Tracking No:

Due Date: 7/29/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG RB6798925 Rev A IPP Rev. A 19.06.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
115	Purchasing	2 pcs	7/29/19		0.00	0.00	Purchasing - 1		AUG 2 0 2019
							Purchasing - 2		
							Purchasing - 3		
118	Packaging 2-1 - Receive - B4B	2 pcs	7/29/19		0.00	0.00	Packaging 2 - 1 - B4B		AUG 2 0 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S207159



Part: RB6798925

Job No: 196890

Serial No/Batch: S207159

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 08/20/19

Plex 6/24/19 10:13 AM Dart.Guerin.Kimberley

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
125	QC 6	2 pcs	7/29/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	81
					QC 6 - 61	9-89
					QC 6 - 40	
130	Packaging 3-1 - Stock - B4B	2 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	DAS
					Packaging 3 - 10 - B4B	77
140	QC 21 - FG	2 pcs	7/29/19	0.00 0.00	QC 21 - FG - 21	9-89
					QC 21 - FG - 70	
					QC 21 - SA - 53	
Part Op 115 - -Issue P/O to ARROW TECH MACHINE WORKS ; P/O _____ -Manufacture RB6798925 as per DWG. - Descriptions: Certificate of Conformity is required 130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
RB6798925P	Gas Producer 2Nd Stage Wheel Locknut Crimper	2 Ea (1 ea)	115-Purchasing	5207156		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
115-Purchasing	RB6798925P	2	0	0		
Part Specifications						
Specifications could not be found.						

Plex 6/24/19 10:13 AM Dart.Guerin.Kimberley



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PURCHASE ORDER POHB043785



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938.

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB043785

PO Date: 6/19/19

Due Date: 7/29/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	196847	RB6872201P			Prop Flange Puller	Firmed -		7/29/19	1 Ea	0 Ea	1 Ea	\$2,048.20/Ea	\$2,048.20
						1X	AUG 0 2 2019						
2	196848	RB6891198P			Wrench	Firmed -		7/29/19	1 Ea	0 Ea	1 Ea	\$1,441.15/Ea	\$1,441.15
						1X	JUL 3 0 2019						
3	196849	RB6796966P	RB6796966P		RET. RING, FUEL CTR. DR. PLIER	Firmed -		7/29/19	2 Ea	0 Ea	2 Ea	\$827.00/Ea	\$1,654.00
								AUG 0 2 2019				AUG 2 0 2019	
4	196851	RB6795614P			Puller/Pusher Idler Gear Support Shaft	Firmed -		7/29/19	2 Ea	0 Ea	2 Ea	\$538.00/Ea	\$1,076.00
						2X	JUL 3 0 2019						
5	196852	RB6795984P			Power Turbine Holder Shaft	Firmed -		7/29/19	2 Ea	0 Ea	2 Ea	\$721.00/Ea	\$1,442.00
						2X	AUG 0 2 2019						
6	196853	RB6872550P			Compressor Rotor Coupler Adapter Holder	Firmed -		7/29/19	2 Ea	0 Ea	2 Ea	\$1,063.00/Ea	\$2,126.00
						2X	AUG 0 2 2019						
7	196854	RB23033037P			Holder Compressor Rotor Coupling Adapter	Firmed -		7/29/19	1 Ea	0 Ea	1 Ea	\$1,408.85/Ea	\$1,408.85
						1X	AUG 0 2 2019						
8	196855	RB6798981P			Prop Shaft Splined Adapter	Firmed -		7/29/19	1 Ea	0 Ea	1 Ea	\$1,207.45/Ea	\$1,207.45
						1X	AUG 0 7 2019						
9	196856	RB6795644P			Bearing Nut Wrench	Firmed -		7/29/19	1 Ea	0 Ea	1 Ea	\$1,387.95/Ea	\$1,387.95
						1X	AUG 0 2 2019						



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Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
10	196857	RB6795588P			Wrench-Holding, 32/64 Pitch 24 Tooth Spline	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$910.00/Ea	\$1,820.00
								2x AUG 0 2 2019					
11	196858	RB23005022P	RB23005022P		INR. PWR. TURB. SHFT. MANDREL	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,645.40/Ea	\$1,645.40
								1x AUG 0 2 2019					
12	196859	RB6795637P			Adapter	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$894.00/Ea	\$1,788.00
								2x JUL 3 0 2019					
13	196860	RB6895528P			Rear Compressor Bearing Pusher	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$772.35/Ea	\$772.35
								1x JUL 3 0 2019					
14	196861	RB6796949P			Accessory Gear Box Bearings Installation Drift	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$292.00/Ea	\$584.00
								2x JUL 3 0 2019					
15	196862	RB6796948P			Drift Install/Removal Accessories Gear Box	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$310.00/Ea	\$620.00
								2x JUL 3 0 2019					
16	196863	RB6872881P	RB6872881P		COMPR MTG INSERT WRENCH	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$327.00/Ea	\$654.00
								2x JUL 3 0 2019					
17	196864	RB6798986P			Prop Shaft Bearing Puller Plate	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$720.10/Ea	\$720.10
								1x JUL 3 0 2019					
18	196866	RB6798983P			Prop Shaft Assembly Drift	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$209.00/Ea	\$209.00
								1x JUL 3 0 2019					
19	196867	RB6796946P			Install & Removal Accessory Gear Box Bearings Drift	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$353.00/Ea	\$706.00
								2x JUL 3 0 2019					
20	196868	RB6795990P			Dummy Bearing Power Turbine Shaft Front	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$304.00/Ea	\$304.00
								1x JUL 3 0 2019					
21	196869	RB6795993P			Joining And Separating Power	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$389.50/Ea	\$389.50
								1x JUL 3 0 2019					



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PURCHASE ORDER

POHB043785



Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
22	196870	RB23034275P			Adapter Pilot Rear Compressor Bearing Puller	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$340.00/Ea	\$340.00
							1 X	JUL 30 2019					
23	196871	RB6798980P			Shaft Spanner Nut Wrench	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,479.15/Ea	\$1,479.15
							1 X	JUL 30 2019					
24	196872	RB6798845P			Turbine 2Nd Stage Spline Adapter	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,038.35/Ea	\$1,038.35
			PS				1 X	JUL 30 2019					
25	196873	RB6872746P			Puller, Power Train Drive Gear Bearing	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$1,950.00/Ea	\$3,900.00
							2 X	AUG 02 2019					
26	196874	RB6893361P			Power Turbine Coupling Inner Race Puller	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$1,071.60/Ea	\$1,071.60
							1 X	AUG 02 2019					
27	196875	RB6872927P	RB6872927P		RED. GEAR FLANGED STUD WRENCH	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$340.64/Ea	\$681.28
							2 X	JUL 30 2019					
28	196876	RB6872477P			Spanner Power Turbine Coupling Inner Nut Wrench	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$579.50/Ea	\$579.50
			PS-				1 X	JUL 30 2019					
29	196877	RB6872202P			Prop Shaft Support Fixture	Firmed	-	7/29/19	1 Ea	0 Ea	1 Ea	\$503.50/Ea	\$503.50
							1 X	JUL 30 2019					
30	196878	RB6795597P			Spanner Wrench	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$649.00/Ea	\$1,298.00
							2 X	AUG 07 2019					
31	196882	RB6796941P			Seals Replacement, Accessories Gear Box	Firmed	-	7/29/19	2 Ea	0 Ea	2 Ea	\$4,053.00/Ea	\$8,106.00
			PS				2 X	JUL 30 2019					
32	196883	RB6798838P			Gas Producer Turbine Tie Bolt	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$691.00/Ea	\$1,382.00
							2 X	AUG 02 2019					
33	196884	RB6796918P			Install Turbine & Exh Colct Support Oil Bellows Seal Dft	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$877.00/Ea	\$1,754.00
								AUG 02 2019					
								2 X	AUG 07 2019				



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Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
34	196885	RB6795594P			Fixture-Assembly, Compressor Rotor	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$1,519.00/Ea	\$1,519.00
							1 X JUL 30 2019						
35	196886	RB23033029P			Fixture Alignment Compressor Rotor Front	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$3,962.50/Ea	\$3,962.50
36	196887	RB6895995-4P			Fixture-Alignment Compressor Rotor (2 Piece)	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$347.70/Ea	\$347.70
							1 X AUG 02 2019						
37	196888	RB6887819P			Gas Producer & Power Turbine Supports Bearing Bore Checking Fixt	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$1,711.34/Ea	\$1,711.34
							1 X AUG 20 2019						
38	196889	RB6872162P			Sump Assembly Pressure Test Fixture	Firmed	-	8/16/19	1 Ea	0 Ea	1 Ea	\$928.62/Ea	\$928.62
							1 X AUG 02 2019						
39	196890	RB6798925P			Gas Producer 2Nd Stage Wheel Locknut Crimper	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$1,410.00/Ea	\$2,820.00
							2 X AUG 20 2019						
40	196895	RB6872880P			Compressor Mounting Inserts Checking Fixture	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$1,905.00/Ea	\$3,810.00
41	196892	RB6796930P			Accessory Gear Box Install Plate	Firmed	-	8/16/19	2 Ea	0 Ea	2 Ea	\$841.00/Ea	\$1,682.00
							2 X AUG 20 2019						
42	196893	RB23006778P	RB23006778P		GUIDE SPUR ADAPTER GEAR SHAFT	Firmed	-	8/16/19	3 Ea	0 Ea	3 Ea	\$427.00/Ea	\$1,281.00
			PS				3 X JUL 30 2019						
Grand Total:												\$64,199.49	



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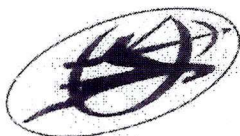
Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 7/30/19 3:41 PM dart.belanger.natasha



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 668

Date: 8/16/2019
PO Ref: HB043785✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
2 ✓	RETAINING RING, FUEL CTR DR. PLIER	RB6796966 ✓
1 ✓	GAS PRO. & PWR TUR. SUP. BRG. BORE CHK	RB6887819 ✓
2 ✓	GAS PRO. 2ND STG WHEEL LOCKNUT CRIMP	RB6798925 ✓
2 ✓	ACCESSORY GEAR BOX INSTALL PLATE	RB6796930 ✓

F - 8128-4801-7394.

RECEIVED

AUG 20 2019

DART AEROSPACE LTD.

Received by:

Packaged by: HE

Checked by: AUP

Thank You

DART SUPPLIER DEVIATION REQUEST

ARR002 - Aug 2019 - 01



A. Supplier Information		B. Part Information	
Date: 08/01/19		Part Number: RB6796966 & RB6798925	
Name: ArrowTech Machine Works		Description: Pliers & Crimper	
Contact: Gabriel Escobar		Revision: 0 & A2	
Phone #: 541-780-6938		PO Number:	
Requestor Title: Production Manager		Quantity of parts affected:	
C. Deviation Information			
Deviation Request is:			
Product Related ☐	1st Time ☒	Permenant ☒	
Process Related ☒	Repeat ☐	Temporary ☐	Duration _____
Current Requirement	Requested Deviation	Reason for Deviation	
Brazing	1/32" filler, Tig welding around meitting Zone	Process Improvement	

DART SUPPLIER DEVIATION REQUEST



D. Corrective Action Taken		E. Preventive Action	
F. DART Approvals	Signature	Date	Approve / Disapprove
Purchasing	<i>[Signature]</i>	06 Aug 2019	APPROVE
Engineering	<i>[Signature]</i>	19-08-08	APPROVE
Manufacturing	—	—	—
Quality	<i>[Signature]</i>	19-08-08	Approve
Other	—	—	—
G. Disposition (Completed by DART)			
Drawing Change Required?	Yes ☐	No ☒	If Yes ECN / URF Number:
Supplier Corrective Action Request Required?	Yes ☐	No ☒	If Yes SCAR Number:
Comments			
This process offers a much cleaner and cosmetic look in tool with out compromising strength in tool.			

DART SUPPLIER DEVIATION REQUEST

ARR002 - Aug 2019 - 01



A. Supplier Information		B. Part Information	
Date: 08/01/19		Part Number: RB6796966 & RB6798925	
Name: ArrowTech Machine Works		Description: Pliers & Crimper	
Contact: Gabriel Escobar		Revision: 0 & A2	
Phone #: 541-780-6938		PO Number:	
Requestor Title: Production Manager		Quantity of parts affected:	
C. Deviation Information			
Deviation Request is:			
Product Related ☐		1st Time XX	Permenant XX
Process Related XX		Repeat ☐	Temporary ☐ Duration _____
Current Requirement	Requested Deviation	Reason for Deviation	
Brazing	1/32" filler, Tig welding arround meitting Zone	Process Improvement	

DART SUPPLIER DEVIATION REQUEST



D. Corrective Action Taken	E. Preventive Action

F. DART Approvals	Signature	Date	Approve / Disapprove
Purchasing	<i>[Signature]</i>	06 Aug 2019	APPROVE
Engineering	<i>[Signature]</i>	19-08-06	APPROVE
Manufacturing	—	—	—
Quality	<i>[Signature]</i>	19-08-06	Approve
Other	—	—	—

G. Disposition (Completed by DART)

Drawing Change Required?	Yes ☐	No ☒	If Yes ECN / URF Number:
Supplier Corrective Action Request Required?	Yes ☐	No ☒	If Yes SCAR Number:

Comments

This process offers a much cleaner and cosmetic look in tool with out compromising strength in tool.



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB043785 ✓ Dated: 8/16/2019

Our Order / Job No: AWT-HB043785 A39 Order Qty: 2 ✓

Part Name: GAS PRODUCER 2ND STAGE WHEEL LOCKNUT CRIMPER

Part Number RB6798925 ✓

Lot Size: N/A Ship Date: 8/16/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB6798925 Rev: A2

Material Size and Type: -1A, 2A/4142 STEEL; -1B, 2B/1018 STEEL; -2C/ O1 STEEL

Material Specifications: STEEL: ASTM A108; O1 STEEL: ASTM A681

Heat Treatment: -1A, -2A/38.0 RC; -2C/60.0 RC

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 8/16/19.

Signed: Armenia Fald

PHGE Machine Works LLC dba Arrow Tech Machine Works
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www.atechmachineworks.com